

Work Order ID 65204



Page 1

Monday, January 10, 2011 7:51:49 AM

Item ID: D3915-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Lid Assembly, Long Basket

Start Date: 1/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 11-01-10 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3915	C

100 Weld per dwg A/R Aluminum rod Batch: _____ 0.00
Large Fab 4112860

Large Fab Memo 0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00
Quality Control

SL 11/01/12 (1x)

Pto →

(1) Ø BE 11/01/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3915-041 PAR #: _____ Fault Category: Large Sub NCR: Yes No DQA: 1 Date: 11.01.20
 Resolution: rework Disposition: rework QA: N/C Closed: 1 Date: 11/01/20

NCR: 65204		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/12	#100	Found during inspection that D4016-5 flange half were not welded in the correct location to Dry.		-cut + Remove D3615-1 Ribs Grinds/Remove all welds.	AS 11/01/13	S 11/01/13		S 11/01/12
		R.C. once D3957 are welded in to location the jig DT9606A cannot be used for welding D4016-5. And were not locate correctly by welder. Lack of Attention		-Re weld AS per Dry D3915-1				
			11.01.12	B# 65337 +1 and D4016-5 B# 58304 +2 AND D4056-1 B 58308 1x A/R. 1115928 AS per 052004	AS 11/01/13	S 11/01/13	11.01.12	S 11/01/12
		D4016-5 scrap x3 B58304.		-Re inspect ac9 weldin inspection	BE 11/01/13 AS 11/01/13			S 11/01/12

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

Sublot 13



QC

Memo

0.00

Quality Control

Fit is tight but ~~ok~~ acceptable

cc

130

Chemical Conversion Coat per QSI005 4.1

0.00

=> all 11/01/13



HandFinish

Memo

0.00

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

1/0

140

Weld per dwg A/R Aluminum rod Batch: _____

0.00

M112860



Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

11/01/14 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE + BE 11/01/14 (x1)

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Sublot 14

Fit on step #120

GK

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

7 W 11/01/17

1 d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 1/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT:

START TIME: 8:15

OVEN TEMPERATURE: 300°

FINISH TIME: 8:45

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 11-01-12

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 294

11/01/12

1 11-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 1/18/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

Signature: [Handwritten Signature]
Date: 1/17/11

71

Signature: [Handwritten Signature]
Date: 1/17/11

W/O 65202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Required Date: 1/18/2011 Req'd Qty: 1.00



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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18 [Signature]
[Signature]
11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

Monday, January 10, 2011 7:51:48 AM

Work Order ID: 65204

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket





Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957  Mounting Plate		Manufactured	No			100	Each	7.0000	4	4		11/01/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				7					
				58302				7					
D3915-1  Rib		Manufactured	No			100	Each	0.0000	2	2		11/01/11	
D4016-5  Hinge Half, Light Lid		Manufactured	No			100	Each	15.0000	3	3		11/01/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ENG				2					
				56075				2					
				ST116				7					
				58304				7					
				WA				6					
				63751				6					
D4019-3  Rib		Manufactured	No			100	Each	4.0000	3	3		11/01/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				4					
				59745				4					

W/O:		WORK ORDER CHANGES					
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Parent Item: D3915-041


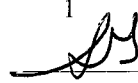

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 1/10/2011

Required Date: 1/18/2011


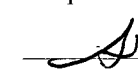

Start Qty: 1.00

Required Qty: 1.00

D4035-045	Manufactured	No	100	Each	1.0000	1	1		 11/01/11
									
Lid Rib Assembly, Fwd (Light)									




<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	1	
59733	1	

D4035-047	Manufactured	No	100	Each	1.0000	1		 11/01/11
								
Lid Rib Assembly, Aft (Light)								


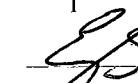

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------




WA	1	
59734	1	

D4056-1	Manufactured	No	100	Each	10.0000	1		 11/01/11
								
Label Plate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	10	
58308	8	
59750	2	

D2728-1	Manufactured	No	180	Each	0.0000	1	1		 11/01/11
									
Dart Logo label									

D4029-041	Manufactured	No	180	Each	4.0000	1	1		 11/01/11
									
Webbing (Long Basket)									

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st503	4	
56963	1	
58109	3	

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 65204

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 1/10/2011

Required Date: 1/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,383.000

34

34



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1383

107939

754

111636

629



Handwritten signature and date 1/11/01/17

NAS1149DN416J

Purchased

No

180

Each

434.0000

34

34



Washer

Location

Loc Qty

Loc Code

ST

4

13910

4

ST275

34

114340

34

ST298

396

114348

52

114597

344



Handwritten signature and date 1/11/01/17

M14606 342

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

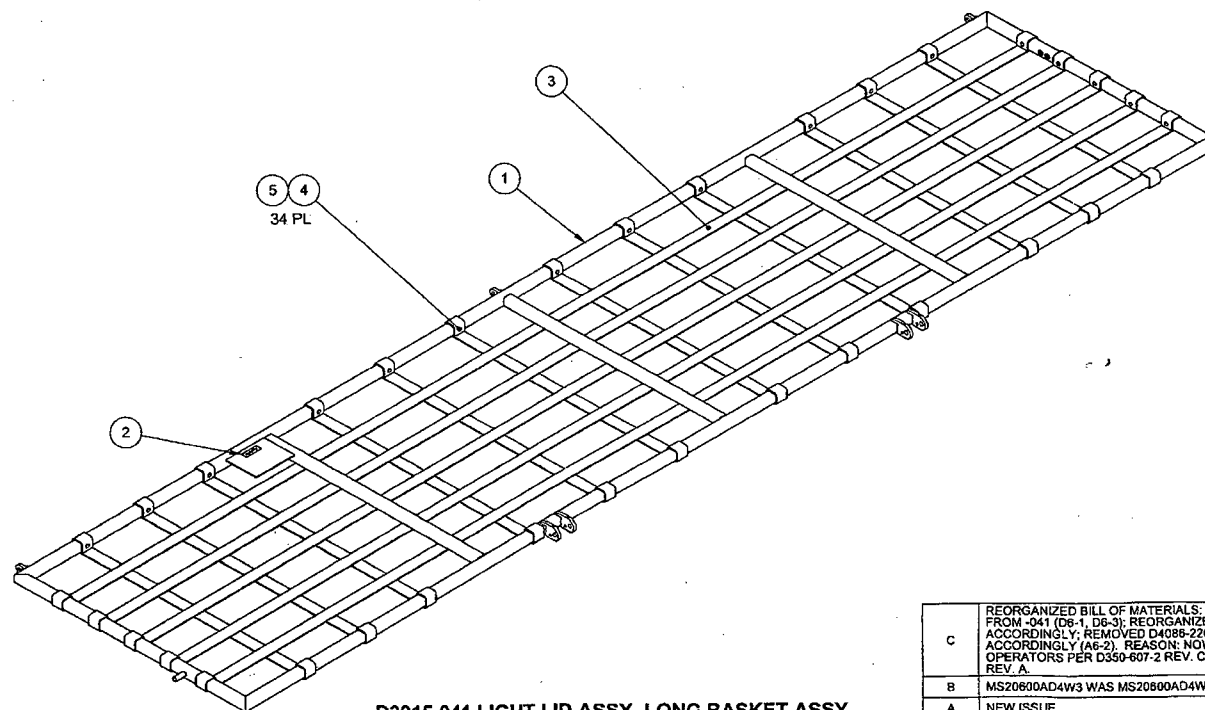
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D8-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
B	MS20600AD4W3 WAS MS20800AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AKS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	S	DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED	M	TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05		
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RELEASED
10.08.12
ECN 10-596

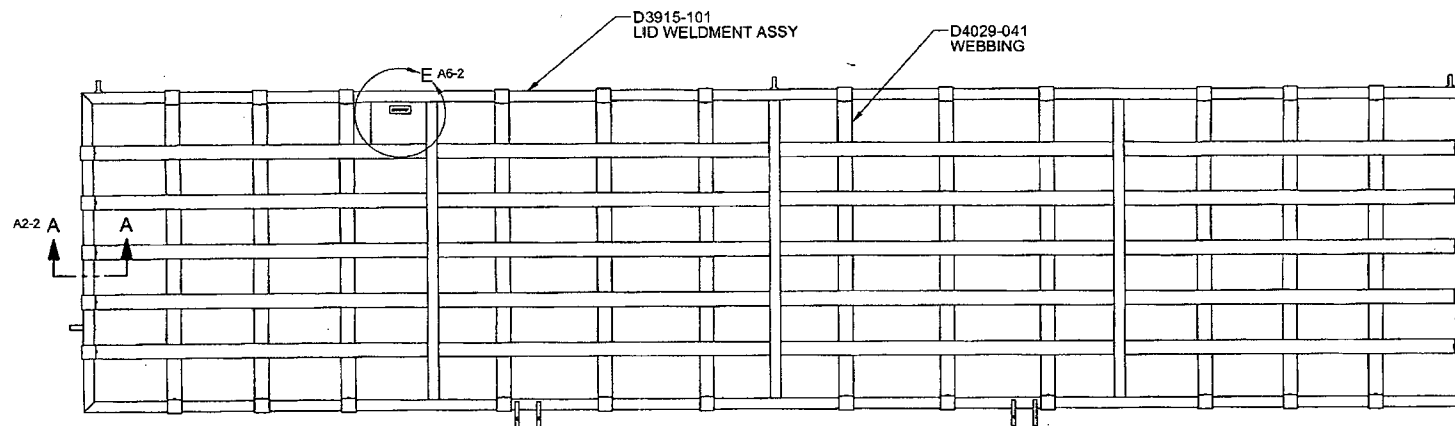
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

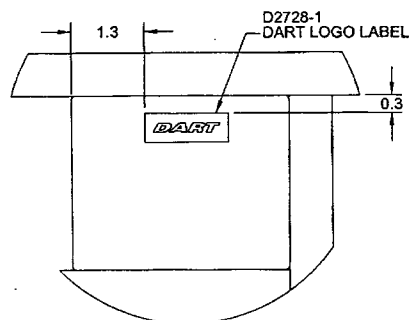
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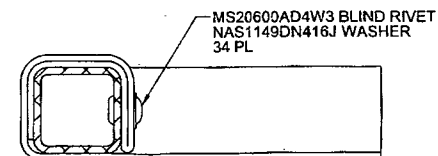
NOTE: Date & initial all entries



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
15.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. C
MFG. APPR.	ALS	D3915	SHEET 2 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	LIGHT LID ASSY-LONG BASKET	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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#65204

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

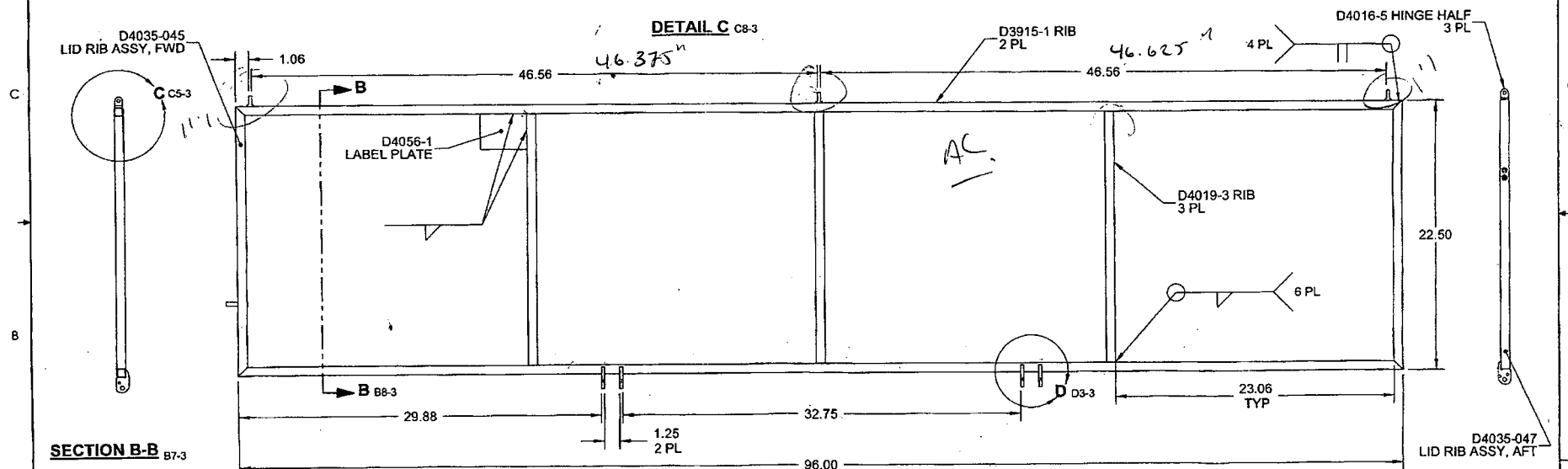
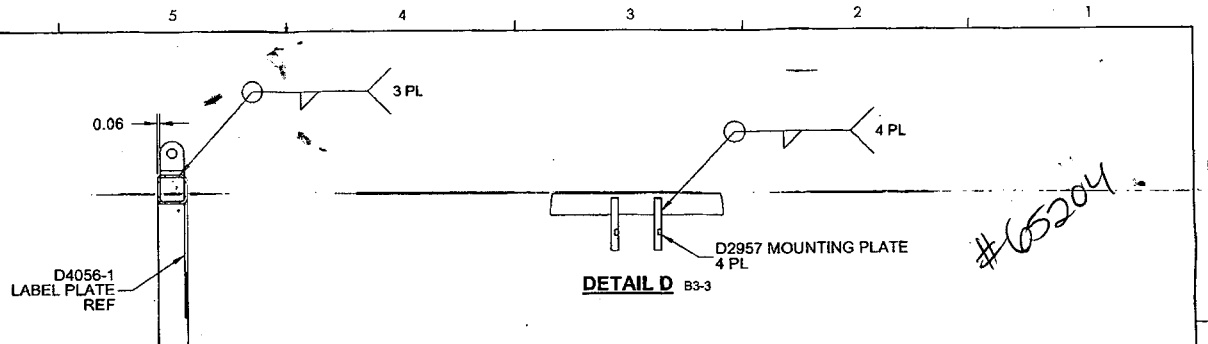
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ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	INTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

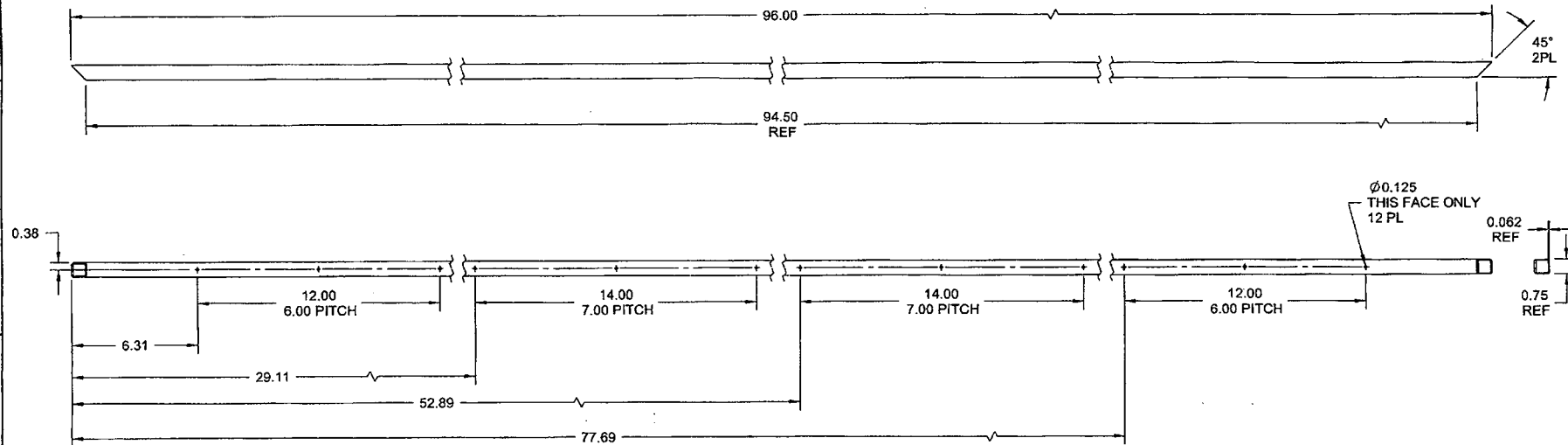
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#66204



D3915-1 RIB

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.49 lbs

RELEASED
10.01.12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3915	REV. C
CHECKED	MP	SHEET 4 OF 4	
MFG. APPR.	MP	SCALE	
APPROVED	MP	TITLE LIGHT LID ASSY-LONG BASKETNTS	
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries